

Date: Monday, 10/11/2008 3:34:19 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LH ACTUATOR ASSEBLY		
Job Number	: 43286		Part Number	: 41232 200 001 001		
Estimate Number	: 12761		Drawing Number	: 41232-200-001 REV IR		
P.O. Number	:		Project Number	: N/A		
This Issue	: 10/11/2008		Drawing Revision	: IR		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 28/11/2008		
Previous Run	: 42218		Qty:	2		
Written By	:		Um:	Each		
Checked & Approved By	: <u>JUL 08 U.11</u>					
Comment	: Est Rev:A New Issue 07-02-28 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:				
1.0	MS208224	elbow	<i>alib9</i>		<i>54</i>	<i>54</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)				
		elbow	<i>M1102363</i>		<i>1st</i>	<i>1st</i>
		Batch: <u>M1102363</u>				
2.0	AN8424D	Elbow			<i>M1102363</i>	<i>1st</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)				
		Elbow	<i>M110138</i>		<i>1st</i>	<i>1st</i>
		Batch: <u>M110138</u>				
3.0	41232 200 007 001	Brass Cylinder Assembly			<i>2X</i>	<i>2X</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)				
		Brass Cylinder Assembly	<i>alib9</i>		<i>54</i>	<i>54</i>
		Batch: <u>342266</u>				
4.0	MS1699623	cap screw			<i>alib9</i>	<i>54</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)				
		cap screw	<i>M103934</i>		<i>1st</i>	<i>1st</i>
		Batch: <u>M103934</u>				
5.0	AN3154R	Nut			<i>1st</i>	<i>1st</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)				
		Nut	<i>M17566</i>		<i>1st</i>	<i>1st</i>
		Batch: <u>M17566</u>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 3:34:19 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEBLY

Job Number: 43286

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD416



Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch:

M109249

88 08/12/02 (2)

7.0 AN960JD10



Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch:

M109061

88 08/12/02 (2)

8.0 MS21042L3



Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch:

M109031

88 08/12/02 (2)

9.0 AN322A



Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M109043

88 08/12/02 (2)

10.0 41232 200 005 003



Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer (Step Actuator)

Batch:

43732

88 08/12/02 (2)

11.0 41232 200 002 005



pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

pivot arm

Batch:

B43305

911129

(2)

51

12.0 41232 200 002 003



latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

latch

Batch:

B43304

2X 10/12/09

911129

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEBLY

Job Number: 43286

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

tube

Batch:

43303

88 08/12/02 (x2)

14.0 41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Decal

Batch:

104079 31780

88 08/12/02 (x2)

15.0 S 1455

spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH:

104079

88 08/12/02 (x2)

16.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF

09/01/29

(2)

17.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 43267

09/01/29

(3)

19.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-30

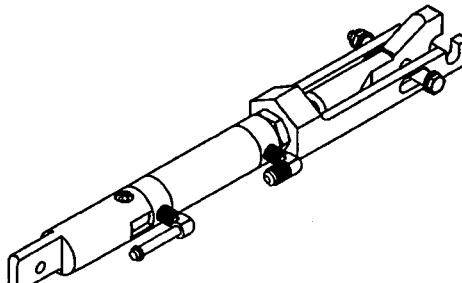
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

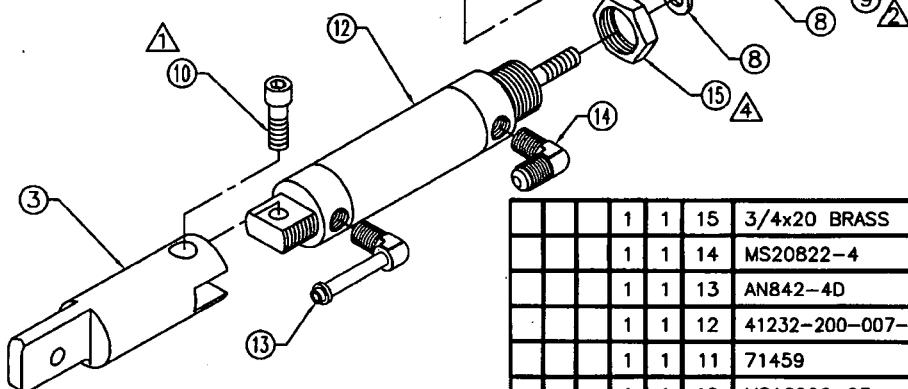
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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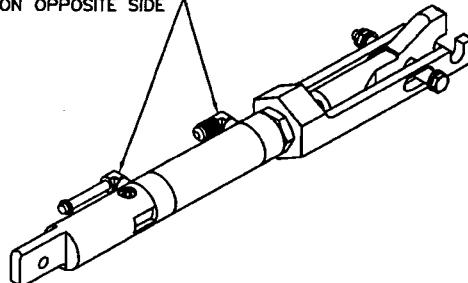
NOTE: Date & initial all entries



-001 L/H ACTUATOR ASSY



INSTALL ITEM #12  
ON OPPOSITE SIDE 



-002 R/H ACTUATOR ASSY

- ▲ TORQUE 80-100 IN.-LB.
- ▲ TORQUE 20-25 IN.-LB.
- ▲ TORQUE 50-75 IN.-LB.
- ▲ TORQUE 50-75 IN.-LB.

**NOTES:**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43286

1	1	15	3/4x20 BRASS	CYLINDER NUT			
1	1	14	MS20822-4	ELBOW			
1	1	13	AN842-4D	ELBOW			
1	1	12	41232-200-007-001	CYLINDER			
1	1	11	71459	SPRING			
1	1	10	MS16996-23	CAP SCREW			
1	1	9	AN315-4R	NUT			
2	2	8	AN960JD416	WASHER			
2	2	7	AN960JD10	WASHER			
1	1	6	MS21042-L3	NUT			
1	1	5	AN3-22A	BOLT			
2	2	4	41232-200-005-003	SPACER			
1	1	3	41232-200-002-005	PIVOT ARM			
1	1	2	41232-200-002-003	LATCH			
1	1	1	41232-200-002-001	TUBE			
		-002		R/H ACTUATOR ASSY			
		-001		L/H ACTUATOR ASSY			
-002	-001	RD NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC
NO.	DESCR	P.D.F.	ITEM	LIST OF MATERIAL			ZONE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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